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RBE703A95-0505-00-15**Job Sheet 191557****Part No:** RBE703A95-0505-00-15**Job Qty:** 6 pcs**Part Name:** TGB Drain Tube Quill Assembly**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/4/19**Job Tracking No:****Due Date:** 4/18/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE703A95-0505-00 Rev.L IPP Rev. A 19.02.27 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	4/18/19		0.00	1.20	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	6 pcs	4/18/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	6 pcs	4/18/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

**Container No:** S168458**Part:** RBE703A95-0505-00-15**Job No:** 191557**Serial No/Batch:** S168458**Revision:** L**Inspector:****Exp Date:****Instructions:**

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Date: 04/01/19

APR 01 2019

Plex 3/4/19 12:46 PM Dart.lajeunesse.marie

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	6 pcs	4/18/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAB 21
					QC 21 - SA - 53	APR 02 2019

Part Op 110 - 1-Cut RBE703A95-0505-00 -9 as per drawing sheet 4. 2-Cut RBE703A95-0505-00 -13 as per drawing sheet 5. 3-Descriptions: Assemble as per drawing note 7 and 8. 4-Pack as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	1.9200 ft (.32 ea)	110-Small Fab - 1	5093319
2044T67	Cap Ø1.09	12 Ea (2 ea)	110-Small Fab - 1	3152045
9263K173	O-Ring	6 Ea (1 ea)	110-Small Fab - 1	3053246
PAD210	Foam Ø1 X 1	.0840 sf (.014 ea)	110-Small Fab - 1	3021250
RBE703A95-0505-00-1	Quill	6 pcs (1 ea)	110-Small Fab - 1	2158368

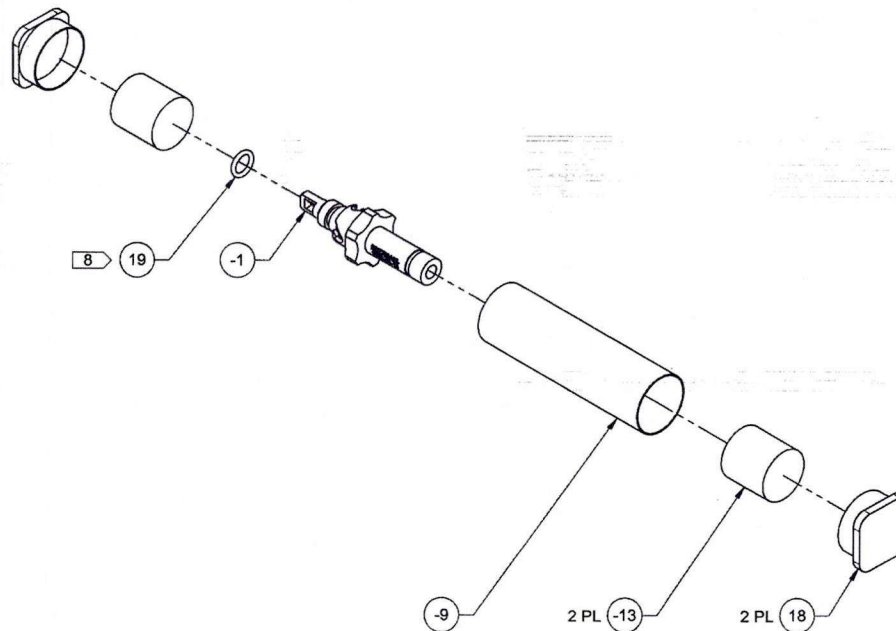
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2044T47	2	60	0
	2044T67	12	199	0
	9263K173	6	28	0
	PAD210	0	3	0
	RBE703A95-0505-00-1	6	22	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0505-00-1	QUILL
-9	1	RBE703A95-0505-00-9	TUBE
-13	2	RBE703A95-0505-00-13	FOAM
18	2	McMaster#2044T67 OR EQUIV.	VINYL END CAP FOR 1.09" ID. SHIPPING TUBE
19	1	McMaster#9263K173 OR EQUIV.	VITON O-RING 9 mm ID. X 13 mm OD. X 2 mm WD.



RBE703A95-0505-00-15 TGB DRAIN TUBE QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 191557 MWS

19-03-01

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE SCALE NTS	REV. L
DRAWN	KPT		SHEET 2 OF 6
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	WJ	DATE	2/26/2019
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					